

Date: Friday, 22/08/2008 10:32:44 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 3" SKID TUBE HEAVY "I" BEAM		
Job Number	: 41591		Part Number	: D26007140		
Estimate Number	: 10057		Drawing Number	: D2600 REV D1		
P.O. Number	:		Project Number	: N/A		
This Issue	: 22/08/2008	S.O. No.	Drawing Revision	: D1		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	: SKIDTUBES			
Previous Run	:		Due Date	: 29/08/2008		Qty: 93
Written By	:				Um: Each	
Checked & Approved By	:					
Comment	: Est. A: 04.11.25 New Issue KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	-PG	PURCHASING
		 Comment: PURCHASING Issue P/O: 7008
		 <i>C208108/22</i>
		<ul style="list-style-type: none"> a) Extrude as per Dwg D2600 b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 40 ksi e) Minimum elongation = 8% f) Order at 140" long g) Caradon Indalex Tool # MS-18872 h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required
2.0	D26007140P	EXT. "I BEAM" THICK
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s) EXT. "I BEAM" THICK
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 <i>HULL S</i> <i>RECEIVED 08/08/08</i> <i>104</i> Receive & Inspect For Transit Damage Ensure material certification is attached
4.0	QC6	DIMENSIONAL CHECK
		Comment: DIMENSIONAL CHECK Inspect dimension per Dwg D2600 Check Pull test per Dwg D2600 for compliance page attached Check hardness with Webster tester

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: HALL 5

08/09/15

104 Hm

centered

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



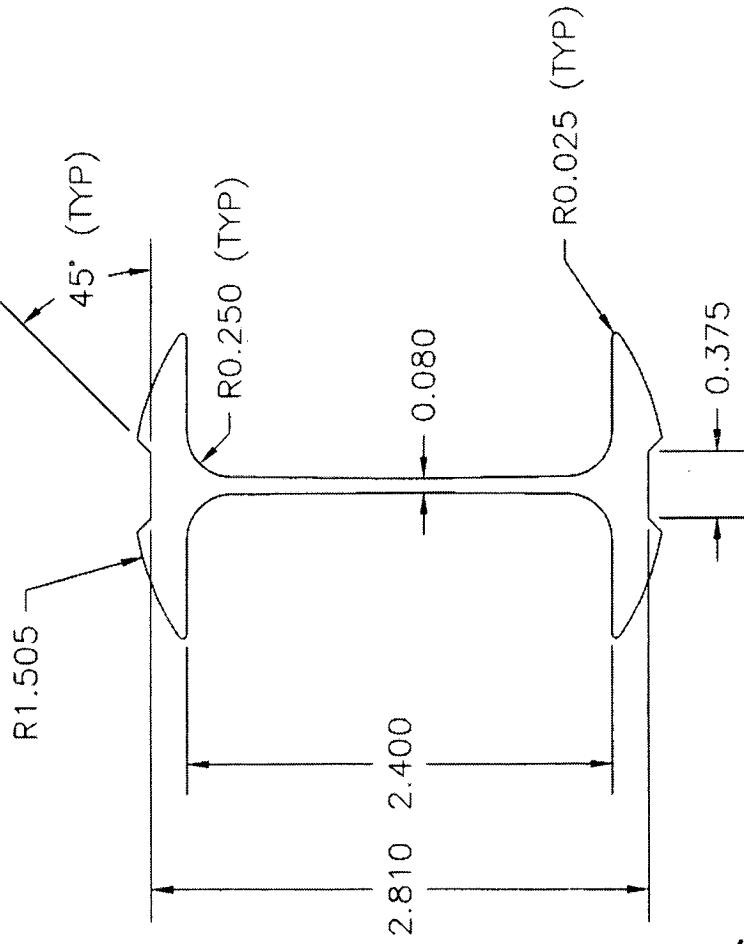
mf 08-09-15



COPY IS
MADE
HERE

DESIGN <i>BB</i>	DRAWN BY <i>AS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>AS</i>	DRAWING NO. D2600	REV. D SHEET 5 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
10.8.25 DS



D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" LONG)



INDALEX LTD.²
525, RUE AVRE
POINTE-CLAIRE (QUÉBEC) H9R 5W8
TÉL.: 514-687-5120 • FAX 514 684 8310

PROFESSONAL ALUMINUM - ANODISATION - FABRICATION - PEINTURE
ALUMINUM EXTRUSIONS - ANODIZING - FABRICATION - PAINTING

P/S# : 676625

8090014

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY, ONT

K6A1K7

CUSTOMER P.S.T. : *6122-5207

EXPÉDIE / SHIPPED

INSTRUCTIONS / NOTES
SPECIAL INSTRUCTIONS

MÉTAL - CARBON

NO. DE CLIENT CUST. NO.	T.P.S. GST	LEXE DE VENTE PROV. PROV. SALE TAX	NO. DE COMMANDE DU CLIENT CUST. ORDER NO.	DATE DE COMMANDE ORDER DATE	NOTRE DATE DE COMP. OUR ORDER DATE	CONDITIONS TERMS	PROJ: Required Date:	
201355	XXXXXX		7008	8/08/25	8/08/25		080829	
VENDEUR SALESMAN	EXPÉDIE PAR SHIP VIA	PAYE PPD.	PIERC COL.	C.A.D. C.O.D.	P.A.B. P.O.R.	EN BALLOTS BUNDLED AND TAPED	CARTONNÉ CARTONED	CARTONNÉ & INTERCALE CARTONED & INNERLEAVED
51	X							
ITEM ITEM NO.	COMMANDÉ / ORDER REQS. POIDS / WEIGHT	N° DE MATRICE INDALEX DIE NO.	DESCRIPTION DU CLIENT CUSTOMER DESCRIPTION	PALETTAGE / STYLING ALLOUÉ / ALLOWED PER MÉTRE LINÉAIRE	CONSIGNATION ALLOCATION PER LINEAR METRE	UNITS OF MEASURE UNITS OF MEASURE	ACOMMANDÉ / ORDERED ITEMS	DISPOSITION DISPOSITION
1	500	93 MS 18872 D2600-7	6061 T6	3556			2	555
		D-2600-7 HEAVY DUTY BUNDLE= 845077	845104					104
F EXTRUDE ONLY DUE=2008/09/12 ASAP							POIDS EN KGS	
							OK	
We hereby certify that the material supplied meets the chemical properties as published by the Aluminum Association and requirements of our Quality procedures							OKS endomagé	
							60	
							#77	
							107 m	
							18/8/10	



325 rue Avro
Pointe-Claire QC H9R 5W3

Téléphone (514) 697-5120
Fac-simile (514) 694-8310

Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : DART AEROSPACE LTD

Adresse / Address : 1270 ABERDEEN STREET
HAWKESBURY ONT,
K6A 1K7

commande Indalex / Indalex order # : 8090014

bon de commande / Purchase order # : 7008

de matrice / Die # : MS 18872 Description : D-2600-7 Heavy Duty Web

Alliage & trempage / Alloy & temper : 6061 T6

Contrôle / Control # : 83196-1

Coulée / Cast # : 44232

S
ocologly

	Min.requis Min.required	Résultat actuel Actual results
Tension ultime Ultimate stress (psi)	38 000	41480
Contrainte élastique Yield stress (psi)	35 000	38434
% élongation dans 2" % elongation in 2"	8	12
Dureté Rockwell E (hrc) Rockwell E Hardness (hrc)	88 @ 100	91

Composition chimique typique / Typical chemical composition :

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti
6063	0,20 - 0,60	0,35 Max	0,10 Max	0,10 Max	0,45 - 0,90	0,10 Max	0,10 Max	0,10 Max
6005	0,60 - 0,90	0,35 Max	0,10 Max	0,10 Max	0,40 - 0,60	0,10 Max	0,10 Max	0,10 Max
6005A	0,68 - 0,72	0,15 - 0,27	0,08 - 0,12	0,20 - 0,24	0,48 - 0,52	0,03 Max	0,05 Max	0,03 Max
6061	0,40 - 0,80	0,70 Max	0,15 - 0,40	0,15 Max	0,80 - 1,20	0,04 - 0,35	0,25 Max	0,15 Max
6351	0,7 - 1,3	0,5 Max	0,10 Max	0,40 - 0,80	0,40 - 0,80	--	0,20 Max	0,20 Max

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221 excepté pour la section 8.2 (nombre de spécimen) et AMS QQA 200/8 excepté pour la section 4.2.3.1 (nombre de spécimen) qui sont déterminés par les exigences du client.

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 except for section 8.2 (number of specimen) and AMS QQA 200/8 except for section 4.2.3.1 (number of specimen) which is determined by customer requirement.

Sincèrement vôtre,
Yours truly,

date : 2008-08-28

Bruno Morency
Technicien de la qualité
Quality technician

Indalex Limited